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मानक

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IS 10068-4 (1997): Press Working Die Sets (Plain Type),
Part 4: Rear Post Rectangular Die Sets [PGD 4: Metal
Forming Machines]



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“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक

प्रेस प्रचालन डाई समुच्चय (सादा टाइप)

भाग 4 पश्च पोस्ट आयताकार डाई समुच्चय — विशिष्ट

Indian Standard

PRESS WORKING DIE SETS (PLAIN TYPE)

PART 4 REAR POST RECTANGULAR DIE SETS — SPECIFICATION

ICS 25.120.10

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

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Price Group 2

FOREWORD

This Indian Standard (Part 4) was adopted by the Bureau of Indian Standards, after the draft finalized by the Metal Forming Machines Sectional Committee had been approved by the Production Engineering Division Council.

The die sets covered in this standard are generally used in Indian industry.

While preparing this standard, assistance has been derived from the data supplied by leading manufacturers and users of the product.

This Standard (Part 4) is one of the parts of the standard on Press working die sets. The other parts of this standard are as follows:

IS 10068 (Part 1) : 1982 Press working die sets (plain type): Part 1 Centre post rectangular die sets

IS 10068 (Part 2) : 1982 Press working die sets (plain type): Part 2 Centre post square die sets

IS 10068 (Part 3) : 1990 Press working die sets (plain type): Part 3 Centre post round die sets

IS 10068 (Part 5) : 1996 Press working die sets (plain type): Part 5 Rear post square die sets — Specification

IS 10068 (Part 6) : 1996 Press working die sets (plain type): Part 6 Rear post round die sets — Specification

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian standard***PRESS WORKING DIE SETS (PLAIN TYPE)****PART 4 REAR POST RECTANGULAR DIE SETS — SPECIFICATION****1 SCOPE**

This standard (Part 4) covers dimensions, material and other requirements for plain type rectangular die sets with two guide posts at the rear.

2 REFERENCES

The following standards contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below:

<i>IS No.</i>	<i>Title</i>
210 : 1993	Grey iron castings (<i>fourth revision</i>)
1030 : 1989	Carbon steel castings for general engineering purposes (<i>fourth revision</i>)
2062 : 1992	Steel for general structural purposes (<i>fourth revision</i>)
2102 (Part 1) : 1993	General tolerances: Part 1 Tolerances for linear and angular dimensions without individual tolerances indication (<i>third revision</i>)
7664 : 1979	Guide posts for press tool sets (<i>first revision</i>)
8127 : 1979	Guide bushes for press tool sets (<i>first revision</i>)

3 TYPES

The rear post rectangular die sets shall be of the following types:

- Type A — Without tapped hole for shank, and
- Type B — With tapped hole for shank.

4 MATERIAL

The top and bottom tool holders shall be of cast iron of grade GG 260 of IS 210 : 1993 or cast steel of grade 23-45 of IS 1030 : 1989 or mild steel of IS 2062 : 1992.

5 DIMENSIONS

The dimensions of rear post rectangular die sets shall be as given in Table 1.

6 GENERAL REQUIREMENTS

The top and bottom tool holders shall be free from cracks, burrs and pits.

7 DESIGNATION

A rear post rectangular die set shall be designated by:

- Its type;
- material (C for cast iron, S for cast steel, and M for mild steel);
- Die space;
- Type of guide post;
- Type of guide bush; and
- Number of this standard.

Example:

A rear post rectangular die set Type A of cast iron having a die space $a_1 \times b_1 = 100 \text{ mm} \times 80 \text{ mm}$ with guide posts of Type B with round end and having length $l = 200 \text{ mm}$ and with guide bush of Type B of length $l = 50 \text{ mm}$ shall be designated as:

Die Set IS 10068 (Part 4) - AC 100×80 along with Guide Posts IS 7664 - BR 25×200 and Guide Bushes IS 8127 - B 25×50

8 MARKING

8.1 Each die set shall be marked with its designation and manufacturer's trade-mark at a prominent place on tool holders.

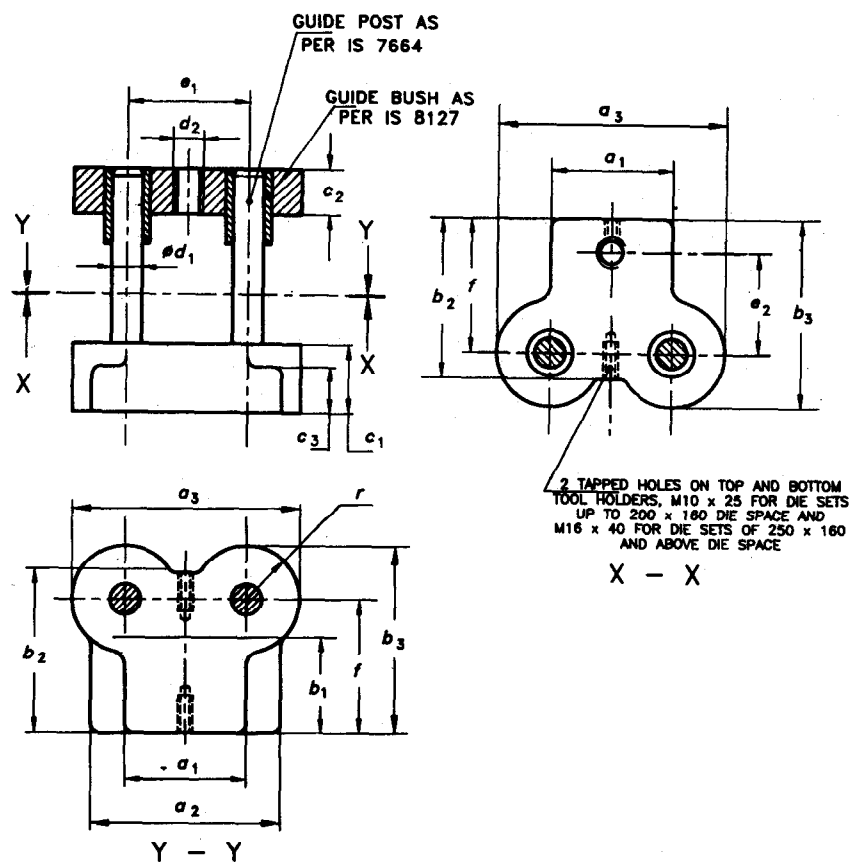
8.2 BIS Certification Marking

The product may also be marked with the Standard Mark.

8.2.1 The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

Table 1 Dimensions for Rear Post Rectangular Die Sets
(Clause 5)

All dimensions in millimetres.



Die Space $a_1 \times b_1$	a_2	a_3	b_2	b_3	c_1	c_2	c_3	d_1	d_2	e_1	e_2	f	r
80 × 63	125	150	105	133	45	30	30	20	M20 × 1.5	80	66	98	35
100 × 63	145	170	105	133	45	30	30	20	M20 × 1.5	100	66	98	35
125 × 63	170	195	105	133	45	30	30	20	M20 × 1.5	125	66	98	35
160 × 63	205	236	105	139	50	32	30	28	M20 × 1.5	160	70	101	38
200 × 63	245	276	105	139	50	32	30	25	M20 × 1.5	200	70	101	38
100 × 80	145	176	130	156	50	32	30	25	M20 × 1.5	100	78	118	38
125 × 80	170	201	130	156	50	32	30	25	M20 × 1.5	125	78	118	38
160 × 80	205	236	130	156	50	32	30	25	M20 × 1.5	160	78	118	38
200 × 80	245	276	130	156	50	32	30	25	M20 × 1.5	200	78	118	38
200 × 80	295	326	130	156	50	32	30	25	M20 × 1.5	250	78	118	38
125 × 100	170	201	150	176	56	40	30	25	M24 × 1.5	125	88	138	38
160 × 100	205	236	150	176	56	40	30	25	M24 × 1.5	160	88	138	38
200 × 100	245	286	150	186	56	40	30	28	M24 × 1.5	200	93	143	43
250 × 100	295	336	150	186	56	40	30	28	M24 × 1.5	250	93	143	43
315 × 100	360	401	150	186	56	40	30	32	M24 × 1.5	315	93	143	43
160 × 125	205	246	180	211	56	40	30	32	M24 × 1.5	160	105	168	43
200 × 125	250	286	180	211	56	40	30	32	M24 × 1.5	200	105	168	43
250 × 125	300	336	180	211	56	40	30	32	M24 × 1.5	250	105	168	43
315 × 125	365	401	180	211	56	40	30	32	M24 × 1.5	315	105	168	43
200 × 160	250	286	225	246	63	50	30	32	M30 × 2	200	123	168	43
250 × 160	300	336	225	246	63	50	30	32	M30 × 2	250	123	203	43
315 × 160	370	415	225	260	63	50	30	40	M30 × 2	315	130	210	50
400 × 160	455	500	225	260	63	50	30	40	M30 × 2	400	130	210	50
250 × 200	305	350	270	300	63	50	30	40	M30 × 2	250	150	250	50
315 × 200	370	415	270	300	63	50	30	40	M30 × 2	315	150	250	50
400 × 200	455	500	270	300	63	50	30	40	M30 × 2	400	150	250	50
500 × 200	560	600	270	300	63	50	30	40	M30 × 2	500	150	250	50
315 × 250	360	415	330	350	63	50	30	40	M30 × 2	315	175	300	50
400 × 250	460	500	330	350	63	50	30	40	M30 × 2	400	175	300	50
500 × 250	560	600	330	350	63	50	30	40	M30 × 2	500	175	300	50
400 × 315	460	514	400	429	75	63	30	40	M42 × 3	400	214	372	57
500 × 315	560	614	400	429	75	63	30	50	M42 × 3	500	214	372	57
600 × 400	560	614	490	614	75	63	30	50	M42 × 3	500	257	457	57

NOTE — Dimensional deviation for untolerenced dimensions shall be of medium class according to IS 2102 (Part 1) : 1993.

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Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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